

The background of the top half of the page is a vibrant blue fabric adorned with numerous small, colorful polka dots in shades of red, yellow, green, and dark blue. A white ribbon is tied into a large, elegant bow in the center of the image, partially overlapping the polka dots. The bottom half of the page is a solid dark purple color.

elna

INSTRUCTION MANUAL 624<sup>DS</sup><sub>E</sub> 614<sup>D</sup><sub>E</sub> 604<sup>E</sup>



# IMPORTANT SAFETY INSTRUCTIONS

When using an electrical appliance, basic safety precautions should always be followed, including the following:

**Read all instructions before using the machine.**

## DANGER To reduce the risk of electric shock:

- The machine should never be left unattended when plugged in.
- Always unplug the machine from the electric outlet immediately after using and before cleaning.
- Always unplug the machine before replacing the bulb. Always replace the bulb with the same type rated 15 Watts maximum.

## WARNING To reduce the risk of burns, fire, electric shock or injury to persons:

- Do not allow the machine to be used as a toy. Pay close attention when the machine is used by or near children.
- Use the machine only for its intended use as described in this manual. Use only attachments recommended by the manufacturer as contained in this manual.
- Never operate the machine if it has a damaged cord or plug, if it is not working properly, if it has been dropped or damaged or dropped into water. Return the machine to the nearest authorized dealer or service center for examination, repair, electrical or mechanical adjustment.
- Never operate the machine with any air openings blocked. Keep ventilation openings of the sewing machine and foot control free from accumulation of lint, dust and loose cloth.
- Keep fingers away from all moving parts. Special care is required around the sewing needle and moving blade.
- Do not use bent needles.
- Do not pull or push fabric while stitching. It may deflect the needle causing it to break.

- Switch the machine off (O) when making any adjustments in the needle area, such as threading needle, changing needle, threading looper, or changing presser foot and the like.
- Always unplug the machine from the electrical outlet when removing covers, lubricating or when making any other user servicing mentioned in the instruction manual.
- Never drop or insert any object into any opening.
- Do not use outdoors. Always store the machine indoors.
- Do not operate where aerosol (spray) products are being used or where oxygen is being administered.
- To disconnect, turn all controls to the off position, then remove plug from outlet.
- Do not unplug by pulling on cord. To unplug, grasp the plug not the cord.
- The machine should be disconnected from the electricity supply when not in use.
- If the power cord of the machine is damaged, it must be replaced by a special cord by your nearest authorized dealer or service center.

# “SAVE THESE INSTRUCTIONS”

**For U.S.A.**

- The foot control type 4C-335B and/or 4C-316B should be used with the machine.
- This appliance has a polarized plug (one blade wider than the other). To reduce the risk of electric shock, this plug is intended to fit in a polarized outlet only one way. If the plug does not fit fully in the outlet, reverse the plug. If it still does not fit, contact a qualified electrician to install the proper outlet. Do not modify the plug in any way.

Dear Customer,

You have chosen an overlock sewing machine of the highest quality, which will make your hours of sewing become hours of pleasure and relaxation.

We congratulate you on your choice and hope that it will give you lasting satisfaction. Before you start to use your machine, please take a few minutes to study this instruction manual. You will find that it will assist you in your complete understanding of the functions and capabilities of your overlock machine.

If you wish to obtain more information, please do not hesitate to contact your dealer who is fully qualified to answer your questions. Furthermore, your dealer should also be contacted for all technical interventions which are under warranty. Thank you for choosing a 600 series overlocker.

Kindest regards,

The manufacturer

## Household Overlock Sewing Machines Models 624DSE, 614DE & 604E

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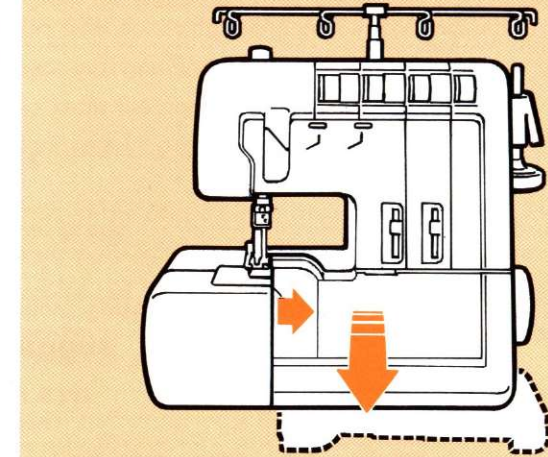
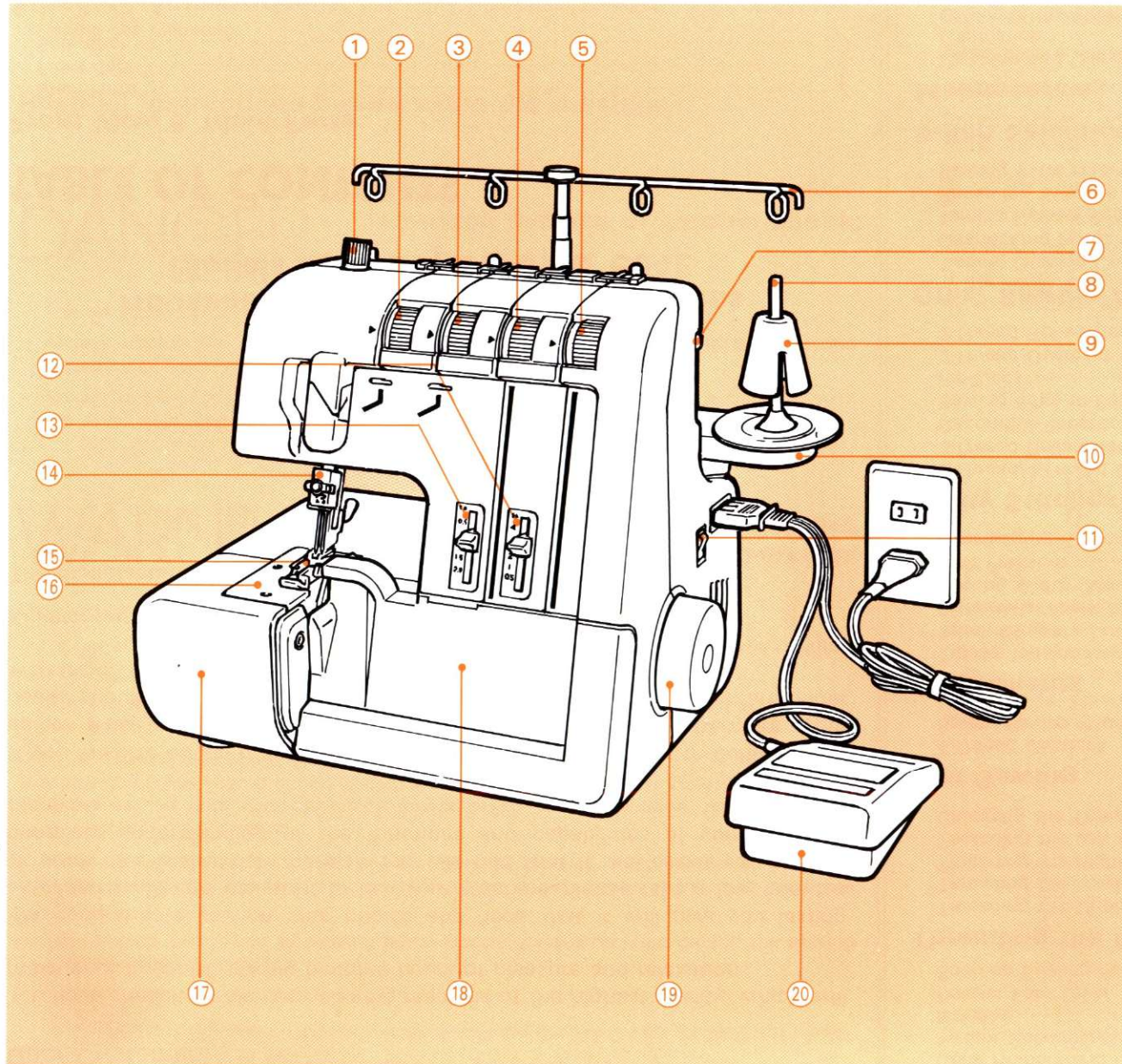
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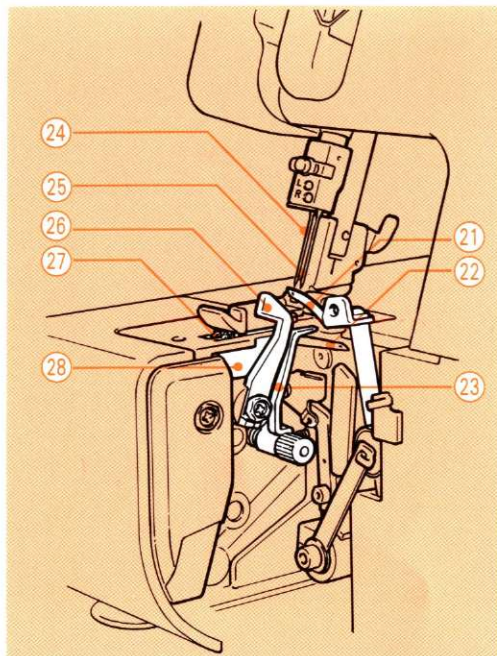
## FRONT VIEW & MAIN PARTS



### Main Parts

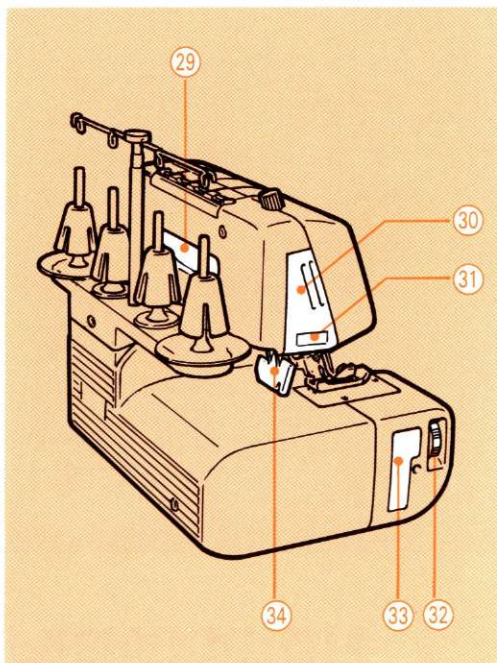
- ① Pressure control knob
- ② Left needle thread tension (blue)
- ③ Right needle thread tension (red)
- ④ Upper looper thread tension (yellow)
- ⑤ Lower looper thread tension (green)
- ⑥ Thread guide pole
- ⑦ Tension release lever (Model 624)
- ⑧ Spool pin
- ⑨ Cone holder
- ⑩ Spool pin base
- ⑪ ON/OFF switch
- ⑫ Stitch length slide
- ⑬ Differential feed control slide (Models 624 & 614)
- ⑭ Needle clamp
- ⑮ Presser foot
- ⑯ Needle plate
- ⑰ Side cover
- ⑱ Front door
- ⑲ Flywheel
- ⑳ Foot control





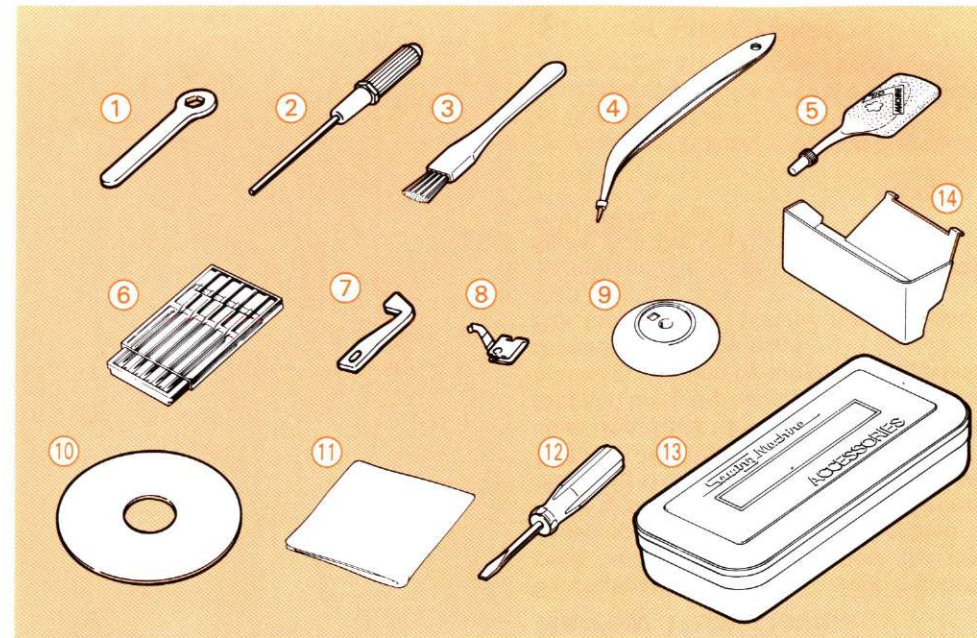
### Front Door

- ②① Upper looper
- ②② Lower looper
- ②③ Instant rolled/narrow hem device
- ②④ Left needle
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- ②⑥ Moving blade
- ②⑦ Feed dogs
- ②⑧ Fixed blade



### Side Cover

- ②⑨ Carrying grip
- ③① Lamp cover
- ③① Sewing light (15 watts maximum)
- ③② Cutting width dial (Models 624 & 614)
- ③③ Moving blade release lever
- ③④ Presser foot lever



### STANDARD ACCESSORIES

Accessory box and accessories included with the machine:

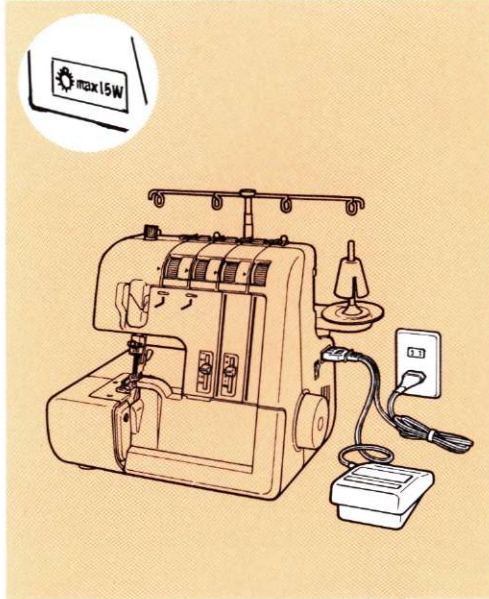
- |                                     |           |
|-------------------------------------|-----------|
| ① Wrench for replacing moving blade | 396001-13 |
| ② Allen screwdriver 1.5mm           | 396002-69 |
| ③ Cleaning brush                    | 396001-69 |
| ④ Tweezers                          | 396001-62 |
| ⑤ Oil tube                          | 396001-70 |
| ⑥ Assortment of needles ELx705      | 396001-51 |
| ⑦ Spare moving blade                | 396001-60 |
| ⑧ 2-thread converter (Model 624)    | 396001-19 |
| ⑨ Spool caps                        | 396002-07 |
| ⑩ Transparent discs                 | 396001-37 |
| ⑪ Dust cover                        | 396002-09 |
| ⑫ Screwdriver                       | 396001-71 |
| ⑬ Accessory box                     | 396001-72 |
| ⑭ Waste tray (Model 624)            | 396001-74 |

### Special Accessories

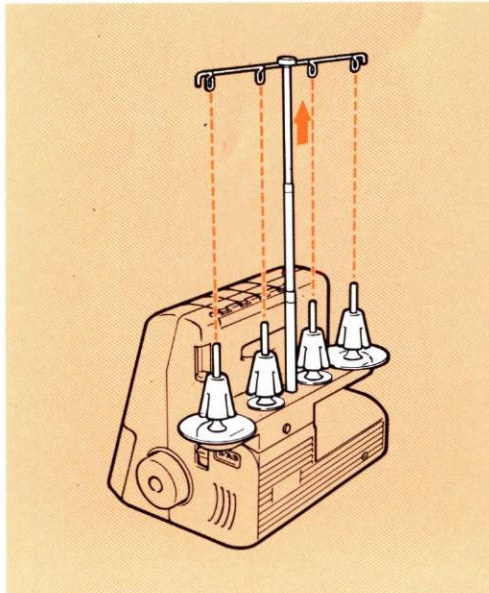
Your dealer will be pleased to give you further details.



## PREPARATION



Connect the foot control, pushing the plug well into the machine plug box. The ON/OFF switch turns the light on (I) or off (O), as well as the supply of electric current to the motor. Switch on to run the machine and off when you are not sewing. The electric foot control regulates motor and sewing speeds. The greater the pressure on the control, the higher the speed. Press preferably with the sole of the foot, not with the toes.

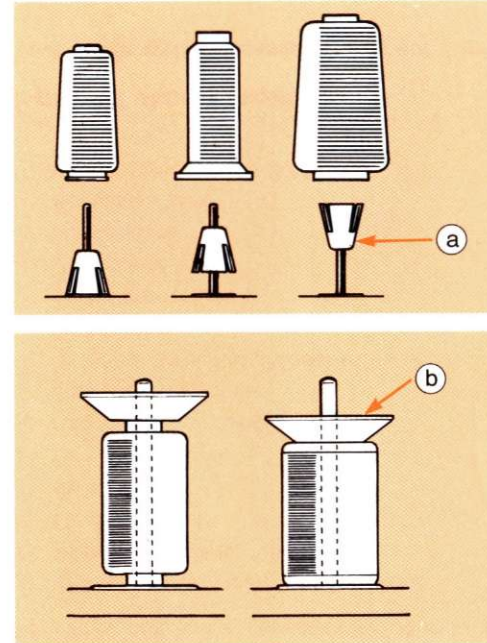


### Extension Discs

2 transparent discs are supplied with the machine. Place them at both ends of the spool pin base, as illustrated, to avoid thread tangling.

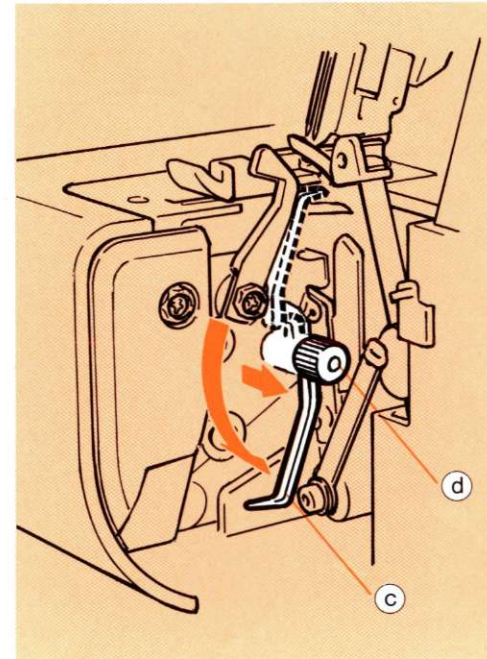
### Thread Guide Pole

Pull the thread guide pole up to the highest position. Make sure that each thread guide is located exactly above its respective spool pin.



### Cone Holders and Caps

Both industrial and domestic type thread spools can be used on the machine. For industrial spools, the cone holders (a). For spools with a large diameter, place the cone holders higher up on the spool pins or place them with the widest end on top (see illustration), so that the spools can be seated firmly on the spool pin base. Place the spools perpendicularly. When using domestic type spools, remove the cone holders and place the caps (b) over the spools of thread.



### Instant Rolled/ Narrow Hem Device

By engaging the lever (c), your machine sews wider overlock stitches. By disengaging the lever (c), your machine is ready to sew a rolled/narrow hem, without changing the needle plate or the presser foot. To disengage the lever (c), first open the front door, raise the presser foot and bring the needle(s) to the highest or lowest position by turning the flywheel towards to you by hand.

Pull the knob (d) first to the right, and then swing it down.

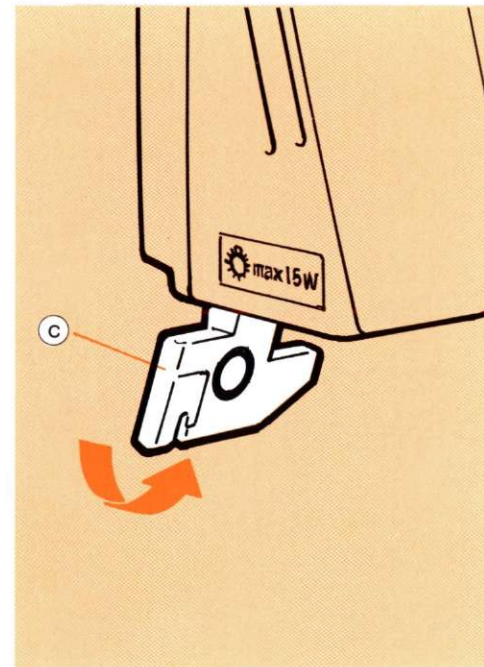
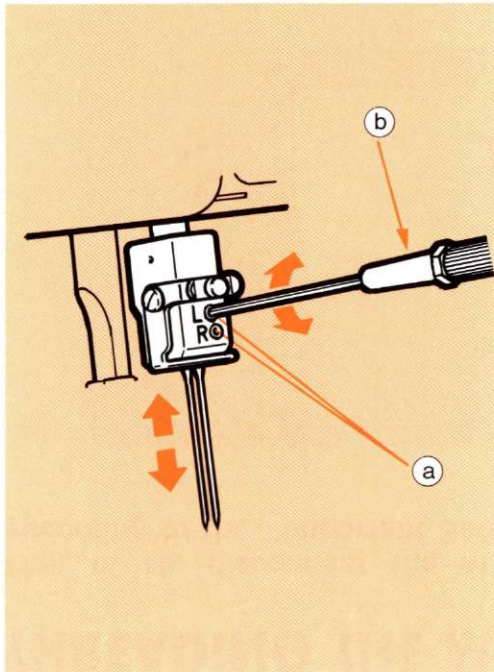
To engage the lever (c), take the same steps, pull the knob (d) to the right, and then swing it up.



## Needles

Your overlock sewing machine has been designed so that it can be used with ordinary household sewing machine needles, 130/705H (15 × 1), but it is nevertheless advisable to use needles EL × 705, for the best stitching results. They are needles for domestic use and can also be used with all ordinary household sewing machines. For normal or thick fabric, use size 90 and for sheer fabric size 80 needles. To change the needles, raise the needle bar to the highest position by turning the flywheel towards you, leaving the presser foot down. Loosen the needle clamp screws (a) with the Allen screwdriver (b), to remove the old needles.

Hold the new needles with the flat side away from you and push them up as far as they will go. Tighten the screws firmly. Make sure that the needles clear the needle plate by turning the flywheel towards you by hand.



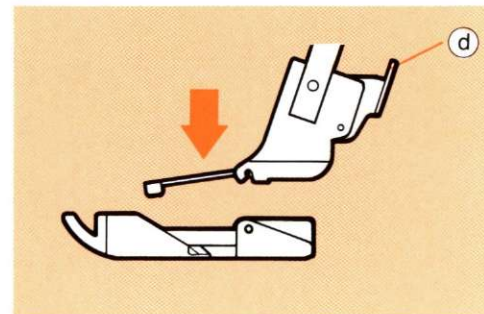
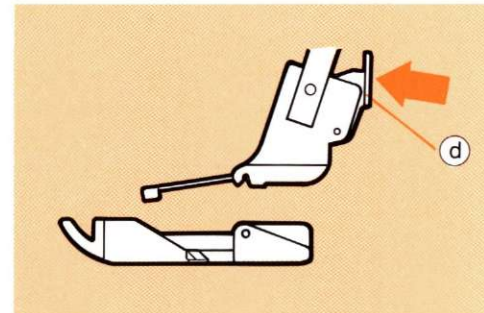
## Presser Foot Lever

To raise the presser foot, swing the lever (c) down and you can see the round mark in red, as illustrated.

To lower the presser foot swing the lever (c) up.

### N.B.

For sewing fluffy or fairly thick fabric, the extra lift (2 mm) will be available by swinging the lever (c) down again.



## Snap-on Sewing Foot

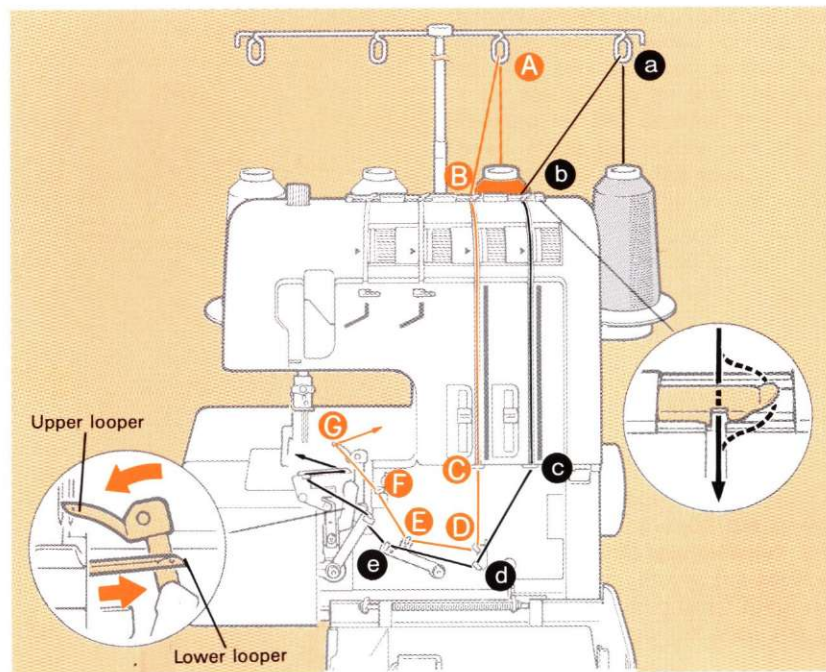
To remove the foot, raise the needle bar and presser bar to their highest positions, then push the lever (d) on the shank.

To lock the foot on to the shank, place the foot under the shank and lower the presser bar.



# THREADING THE MACHINE

First of all, disconnect the machine from the electric outlet according to the "Important Safety Instructions" on page "0".



Follow the threading paths carefully, in accordance with the charts inside the front door, in the sequence 1-2-3-4. It is important that threading is carried out in the following sequence:

1. Upper looper thread – Yellow thread guides
2. Lower looper thread – Green thread guides
3. Right needle thread – Red thread guides
4. Left needle thread – Blue thread guides

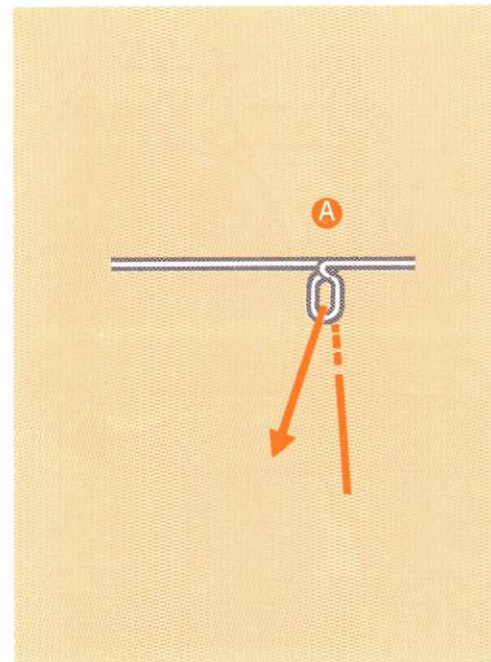
Incorrect threading will result in several problems such as skipped stitches and thread breakage.

Before starting to thread, make sure that the instant rolled/narrow hem device is well engaged on the needle plate.

## Threading the Upper Looper

– Coloured yellow on the chart and on the thread guides.

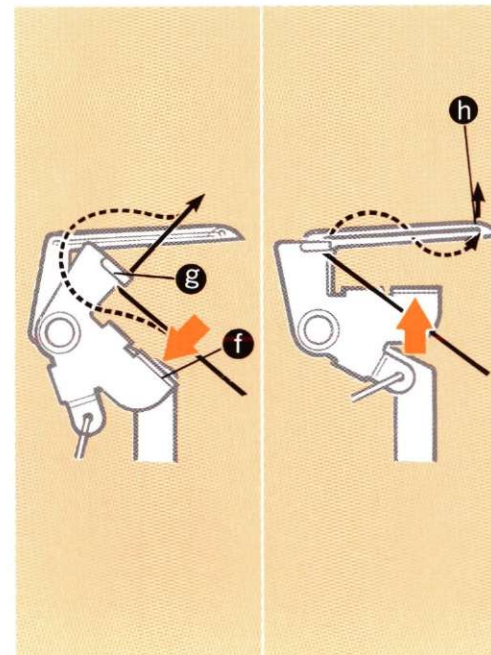
1. Draw the thread from the spool, as shown on the diagram, pass the thread through the guides (A) and (B).
2. Draw the thread down between the two tension discs of the yellow tension control, then through the other thread guides and the hole in the upper looper, steps (C) to (G). Draw the thread back under the presser foot, leaving about 10 cm of thread to the left.



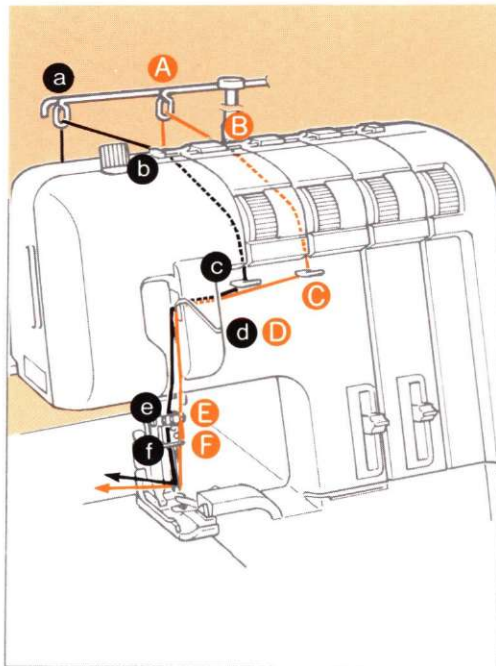
## Threading the Lower Looper

– Coloured green on the chart and on the thread guides.

1. Follow a similar procedure as above, and also shown on the diagram, steps (a) to (e).
2. Bring the lower looper to its right position by turning the flywheel by hand.
3. Push the lever (f) down and hook the thread on the guide (g), push the lever (f) up to the working position, then pass the thread through the eye (h) at the far right end of the looper.
4. Draw the thread back under the presser foot, leaving about 10 cm to the left.







## Threading the Right Needle

- Coloured red on the chart and on the thread guides.

Raise the needle bar to the highest position. Pass the thread through the guides (A) to (C). Pass the thread through the open slot of the take-up lever cover (D) and down to the guides (E) and (F). Finally thread the right needle from front to back, then under the foot, leaving about 10 cm of the thread to the left.

## Threading the Left Needle

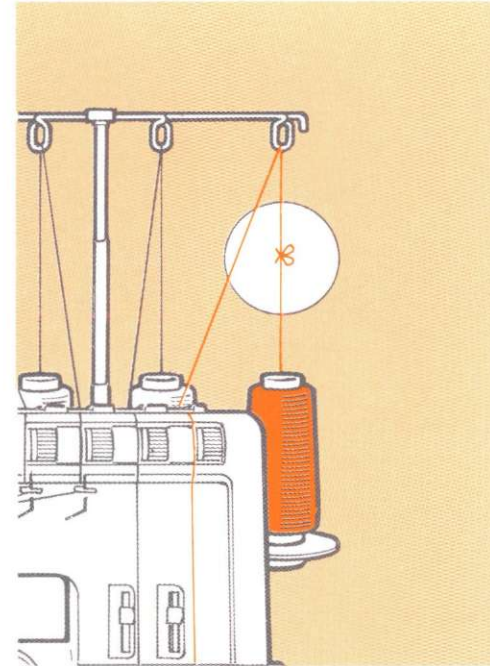
- Coloured blue on the chart and on the thread guides.

Follow a similar procedure as above, and also shown on the diagram, passing the thread through the thread guides and left needle tension and finally thread the left needle, steps (a) to (f).

Before starting to sew, check again that all the threads have been properly passed through every thread guide and are well engaged between the two tension discs of each tension control, to ensure good sewing results.

### N.B.

Should it be necessary at any time to re-thread the lower looper, always remove the thread from the needles first, to avoid tangling.

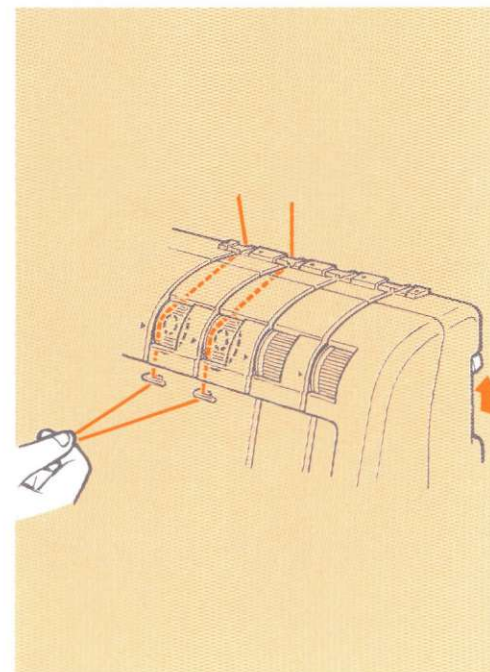


## Changing the Threads

If the machine has already been threaded and you wish to change the threads, tie the new threads to the old threads between the thread guide pole and the top thread guides. First release (Model 624) or loosen the tensions, then pull the looper threads gently behind the needle until the knots have passed through. Next pull the needle thread gently and bring the knots to the front of the needles. Cut the thread at both ends of the knots and pass them through the respective eyes of the needles.

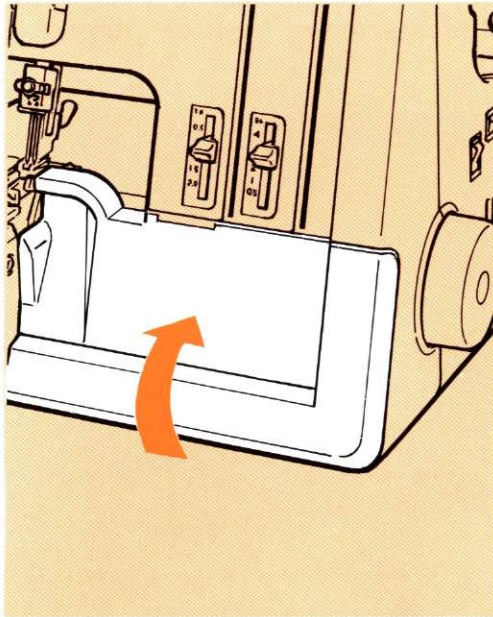
### N.B.

It is advisable to raise the tension release lever so that the two tension discs of the red and blue tension controls open. You can pull the needle threads in front of the needles easily (Model 624).





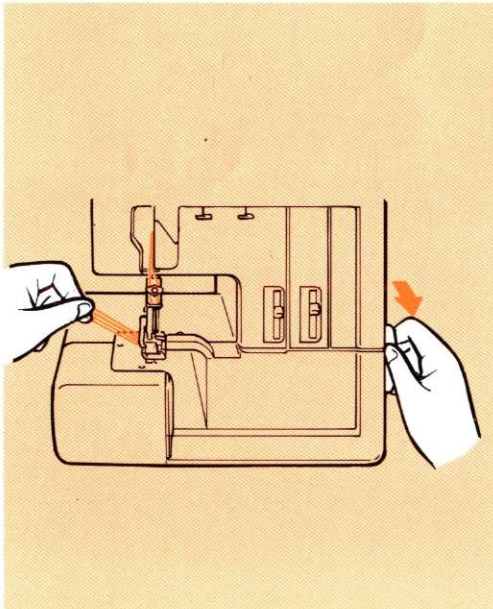
# TEST SEWING



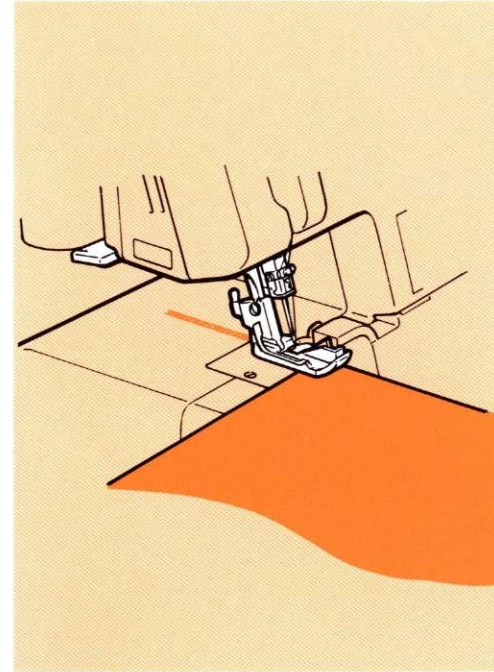
## 4-Thread Overlock

After the machine has been threaded, start sewing in the following sequence:

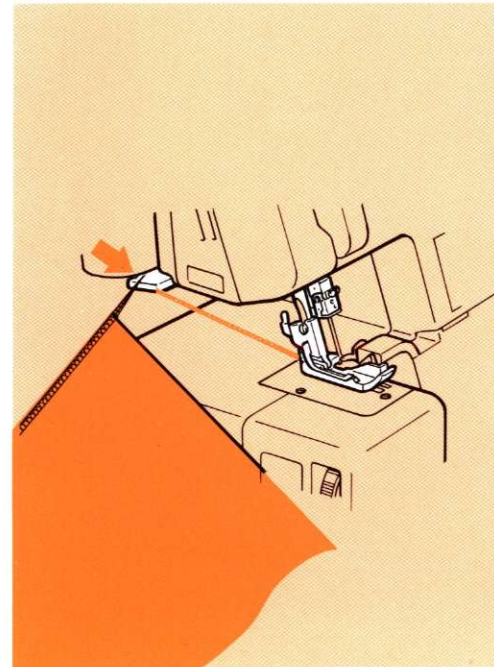
1. Make sure that the front door is closed.



2. Pass the 4 threads under the foot as shown in the drawing. Lower the presser foot, make a few stitches by hand, turning the flywheel towards you (without fabric under the foot). Press on the foot control to make 3 to 4 cm of overlock chain, holding the threads on the left. The machine is now ready to sew.



3. Place a scrap of fabric to be stitched in front of the presser foot, then depress the foot control. Do not pull the fabric; guide it gently.



4. When you reach the end of the fabric, do not raise the presser foot, continue sewing at low speed for about 10 cm beyond the end of the fabric so that the machine produces a chain of thread. Then cut the thread with the thread cutter (see illustration). You are then ready to start the next seam. You can start overlocking from the edge of the fabric just by feeding it into the front of the lowered presser foot.
5. If the stitches are not formed correctly, check if the threading routes are correct first and adjust the tensions in accordance with the instructions on the next pages.

### N.B.

Do not raise the presser foot at the end of a seam but always sew a chain of thread at least 10 cm long.

### Safety Device (Model 624)

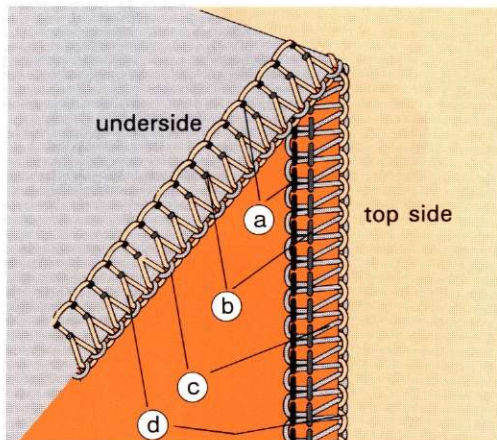
The front door is provided with a safety device. If it is open, the machine will not work.



# ADJUSTMENTS

The thread tensions should be adjusted according to the type and thickness of both thread and fabric. Turn the tension knobs referring to the numbers on the dials; turning to a higher number will increase the thread tension and to a lower number decrease it.

## Thread Tensions

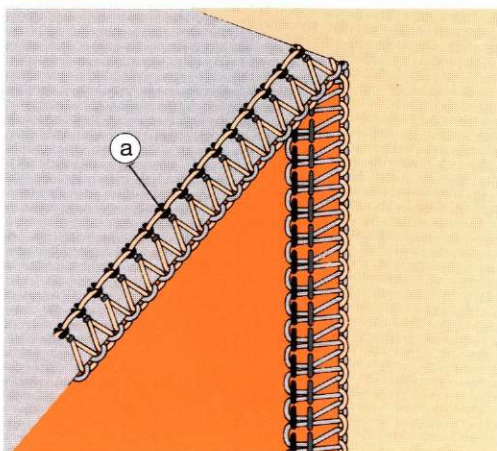


### 1. A balanced tension

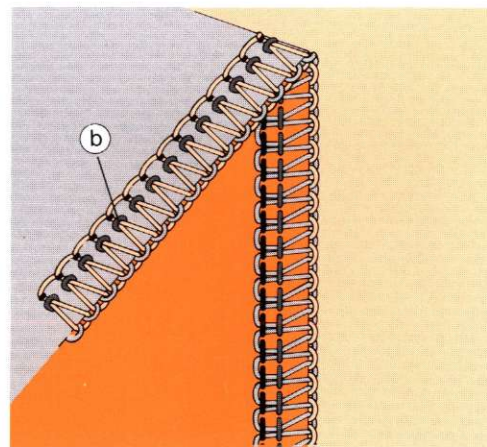
(a) – (b) The needle threads lie on the top side of the fabric (just like a row of normal straight stitches) on the upper looper thread, and just visible in the lower looper thread on the underside of the fabric.

(c) The upper looper thread lies flat on the top side of the fabric and locks with the lower looper thread on the edge of the fabric.

(d) The lower looper thread lies flat on the underside of the fabric and locks with the upper looper thread on the edge of the fabric.



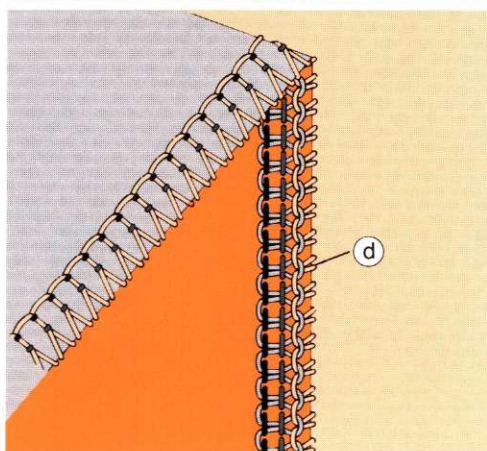
2. If the left thread (a) is too loose and clearly visible on the underside of the fabric, increase the left needle thread tension and/or decrease either or both looper thread tensions.



3. If the right needle thread (b) is too loose and clearly visible on the underside of the fabric, increase the right needle thread tension.



4. If the upper looper thread (c) is loose and pulled over to the underside of the fabric, increase the upper looper tension and/or decrease the lower looper tension.



5. If the lower looper thread (d) is loose and pulled up onto the top side of the fabric, increase the lower looper tension and/or decrease the upper looper tension.

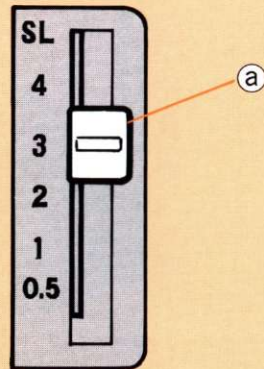
### N.B.

If the thread tensions are too tight, the fabric will pucker.



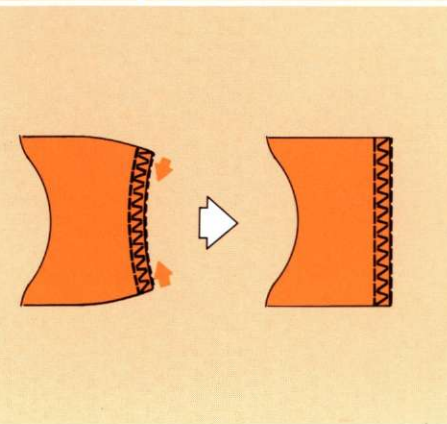
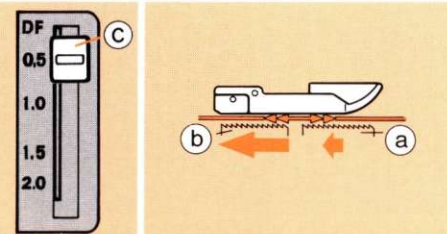
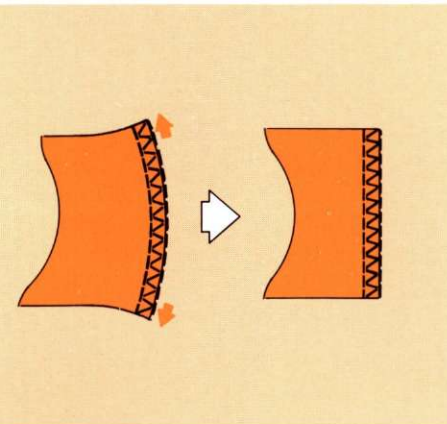
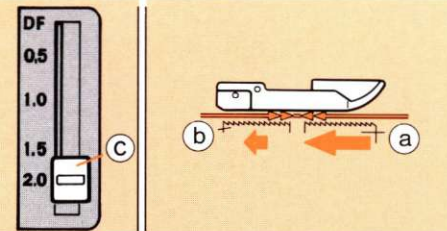
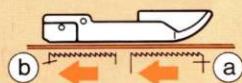
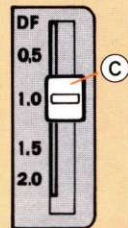
## Stitch Length

Most overlock sewing projects can be done with the stitch length set at 2 to 3. However, you can easily change the stitch length by shifting the stitch length slide (a) between 0.5 and 4, as desired.



## Differential Feed (Models 624 & 614)

1. Your machine is equipped with two feed dogs (a) and (b), each of which moves independently. However, when the differential feed control slide (c) is set at 1.0, both feed dogs move together to the same length.



2. By pushing the differential feed slide (c) down to a higher number, the front feed dog (a) moves the fabric faster, as shown. This helps to prevent knitted or stretch fabrics from puckering and waving during sewing.

3. By pushing the differential feed slide (c) up to a lower number, the front feed dog (a) moves the fabric more slowly, as shown. This helps to prevent sheer and lightweight fabrics from puckering.

Always test sew on a scrap of your fabric before starting garment or craft constructions.

### N.B.

Adjustments to the differential feed can be made while sewing.

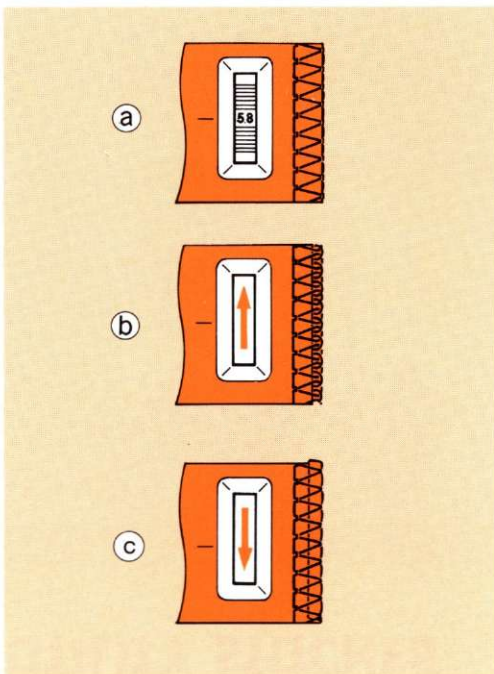




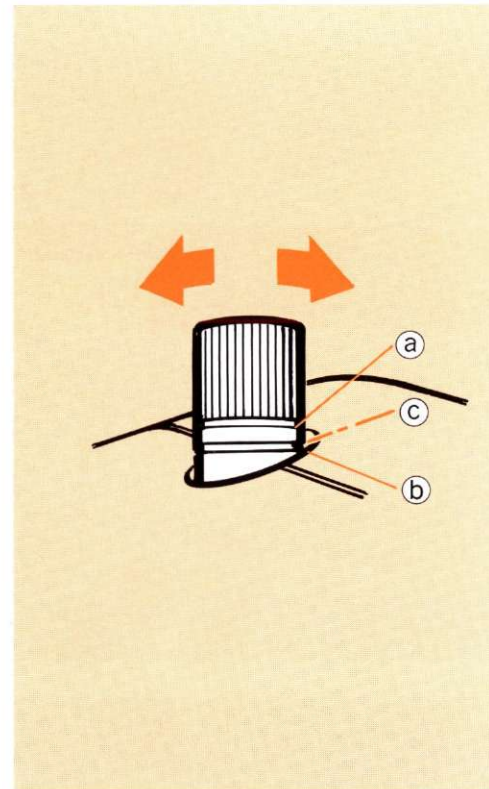
## Cutting Width (Models 624 & 614)

The cutting blades are pre-set at the factory so that most overlock sewing projects can be done without changing their position. For very special fabric types, however, you might at times want to adjust the cutting width.

1. To change the cutting width, bring the needle bar to the highest position.
2. Turn the cutting width dial upwards to increase the width, or downwards to decrease it.
3. Sew a scrap of the fabric to check the sewing result, referring to the illustrations.



- (a) Correct
- (b) The cutting width is narrower than the stitch width. Turn the dial upwards to increase the cutting width.
- (c) The cutting width is wider than the stitch width. In this case, the fabric might be rolled or the needle thread tension might become loose. Turn the dial downwards to decrease the cutting width.

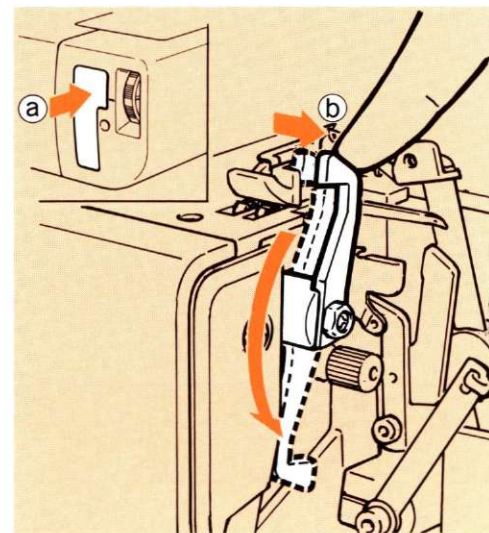


## Foot Pressure

With the guide line (a) of the pressure control knob even with the top cover surface (b), the foot pressure is suitable for most kinds of fabrics and rarely needs adjusting. For special fabric types, however, you might at times want to adjust the pressure slightly.

1. For very slippery fabrics, tighten the knob clockwise slightly to increase the pressure.
2. For very stretchable fabrics, loosen it counter-clockwise to decrease the pressure.

With the lower guide line (c) of the pressure knob at higher level than the top cover surface, lower pressure for very stretchable fabrics is available.



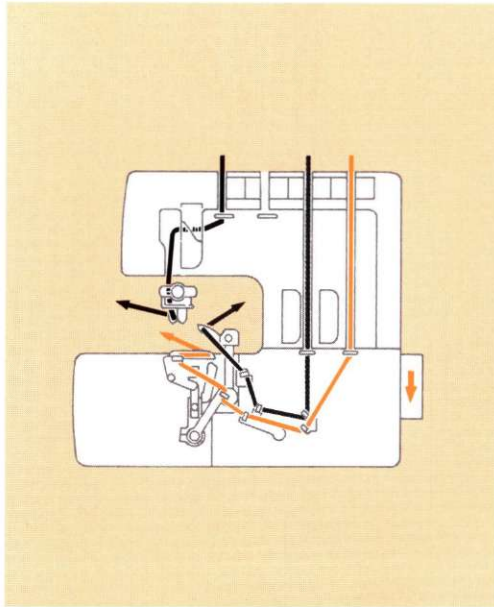
## Disengaging/Re-engaging the Moving Blade

By disengaging the moving blade, you can enjoy various sewing techniques.

1. To disengage the moving blade, first open the front door.
2. Push the moving blade release lever (a) to the right and the moving blade will stop at (b) position.
3. Turn it towards you by hand.
4. To re-engage the moving blade, push the moving blade release lever to the right and turn it towards the back, then release the lever.



# UTILITY STITCHES

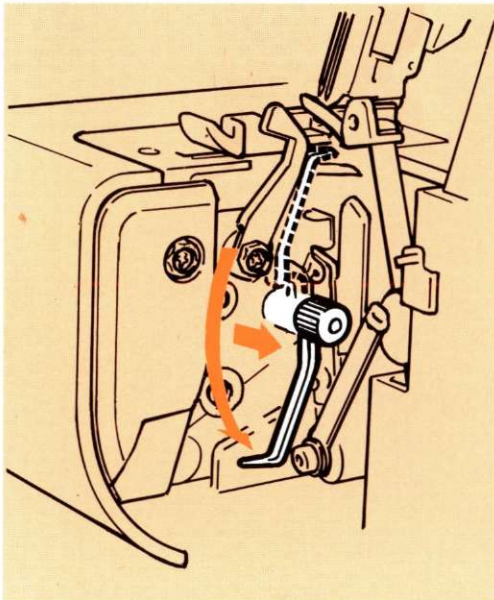


## 3-Thread/4-Thread Overlock

- Using the left needle, a 3-thread overlock 7.0 mm wide can be sewn.
- Using both needles, a 4-thread overlock 7.0 mm wide can be sewn.
- Using the right needle, a 3-thread overlock 3.7 mm wide can be sewn.

### N.B.

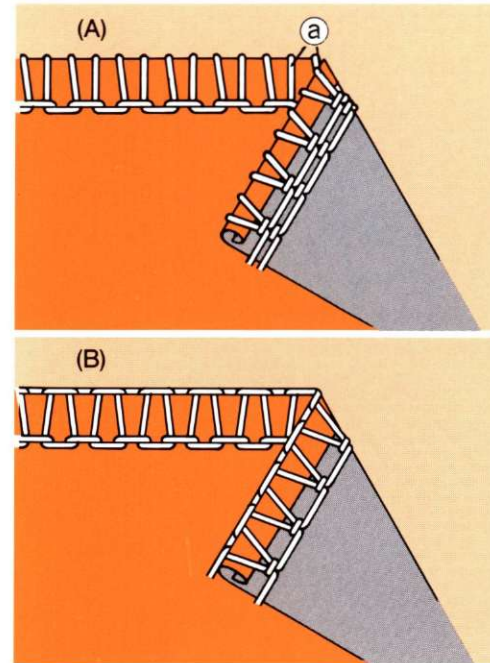
Whenever sewing with 3-thread, remove the needle and tighten the needle clamp screw you are not using.



## 3-Thread Rolled/Narrow Hem

By disengaging the instant rolled/narrow hem device, your machine is ready to sew a rolled or narrow hem on light weight and sheer fabrics.

The tension settings for the rolled or narrow hem are slightly different from those of the regular 3-thread overlock. Refer to the following illustrations.

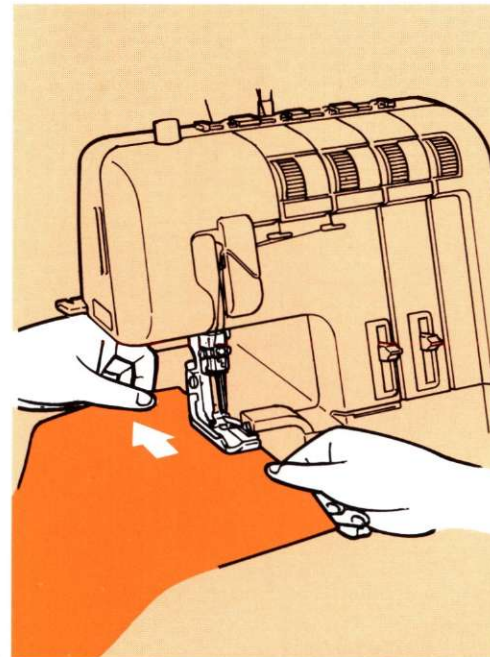


### (A) Rolled hem (Right needle only)

Decrease the upper looper thread tension slightly and increase the lower thread tension as required so that the upper looper thread (a) is completely rolled down to the underside of the fabric.

### (B) Narrow hem (Right needle only)

Increase both looper thread tensions slightly so that the looper threads are firmly locked together on the edge of the fabric.

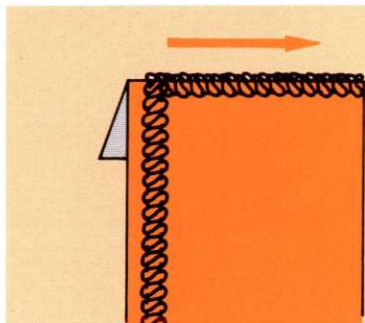


Sew on a scrap of fabric and adjust the tensions according to the illustration, depending on the desired finish. It is recommended to use stretch threads, such as woolly nylon in the upper looper or both loopers.

### N.B.

If the fabric tends to pucker, guide it by gently pulling it to the back with your left hand, and at the same time lightly holding it with your right hand, for good stitching results.



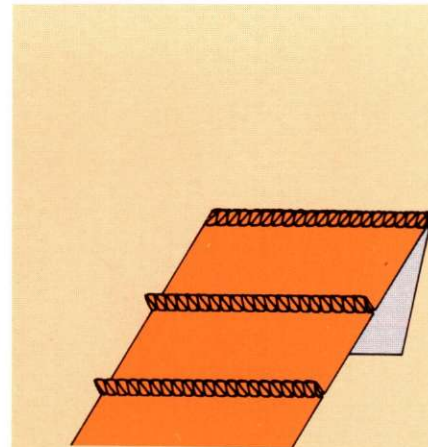
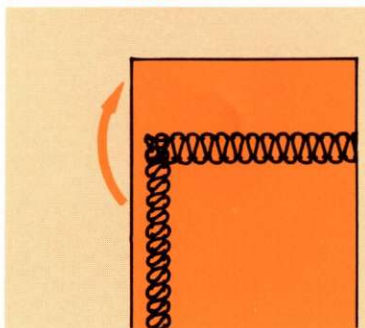


### Decorative Topstitching /Flatlock (Left needle only)

For topstitching with 3 threads, adjust the thread tensions so that the lower looper thread lies straight at the edge of the fabric by greatly loosening the needle thread tension and slightly loosening the upper looper thread tension.

1. Disengage the moving blade (see page 11).
2. Fold the fabric along the line to be topstitched and sew over the folded edge.
3. Unfold the fabric, pull the ends of the thread to the underside and press flat. The final appearance can be enhanced by using a heavy decorative thread suitable for overlock use in the looper(s).

By using the 2-thread convertor on the upper looper, 2-thread flatlock will be available (Model 624).

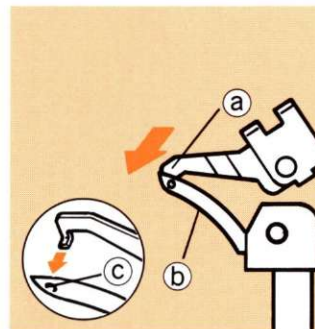
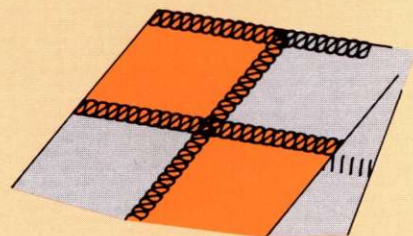
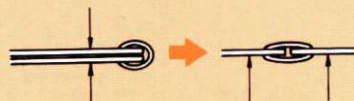


### Pin-Tucks

Disengage the moving blade (see page 11). Fold the fabric along the line to be pin-tucked, sew along the folded edge and press.

### Sewing Edge-to-Edge

Align the edges of the two pieces of fabric, with their wrong sides facing each other, and proceed in a similar manner as above. Unfold and press. By using different coloured fabrics and threads, an attractive "patchwork" effect can be achieved.

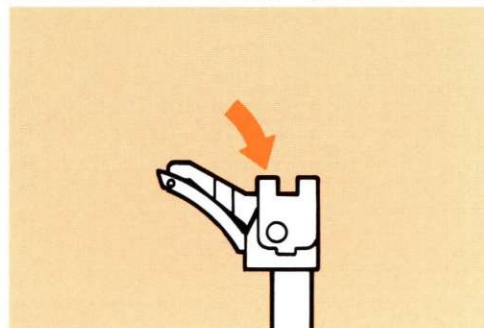


### 2-Thread Overcast (Model 624)

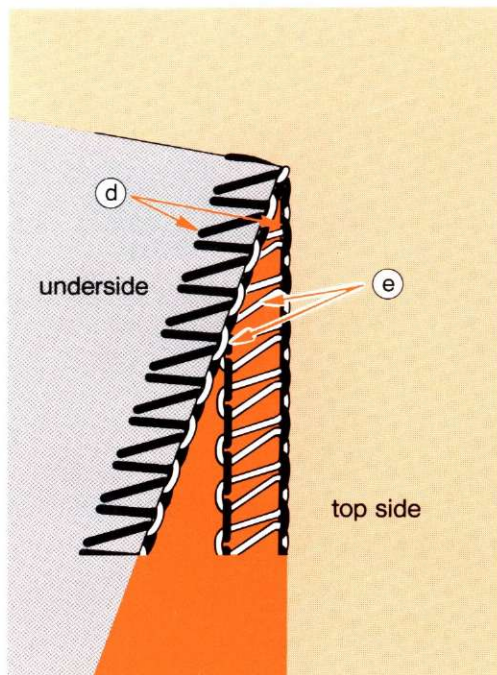
With the 2-thread convertor (a) and using a single needle, your machine can sew a 2-thread overcast which is often used for overcasting a single layer of fabric for decorative topstitching (flatlock), etc.

1. Remove the needle you are not using (the same as for 3-thread use) and the upper thread from the machine.
2. To fit the 2-thread convertor on to the upper looper (b), first insert the tip of the convertor into the upper looper eye from the back, then snap the other end securely into the hole (c) of the upper looper.

The tension settings for the 2-thread overcast are different from those of 3-thread use. Pre-set the needle and lower looper thread tension controls at 0.5 and 6.0, respectively.

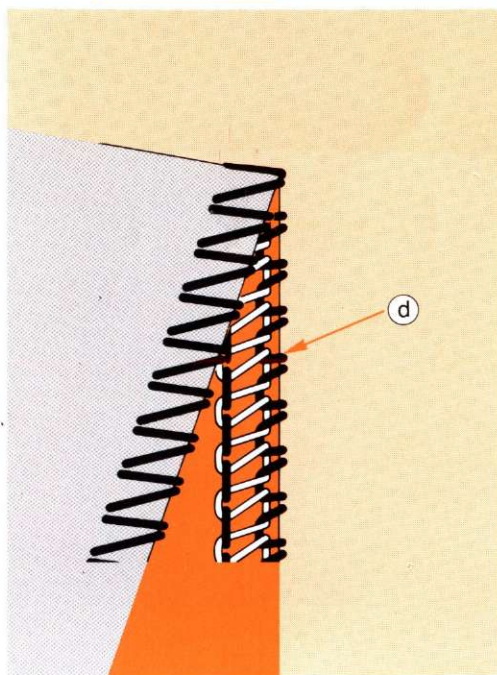




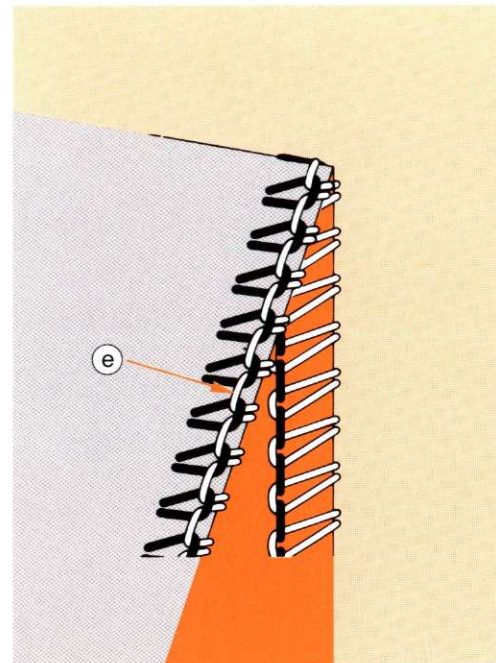


### 3. A balanced tension

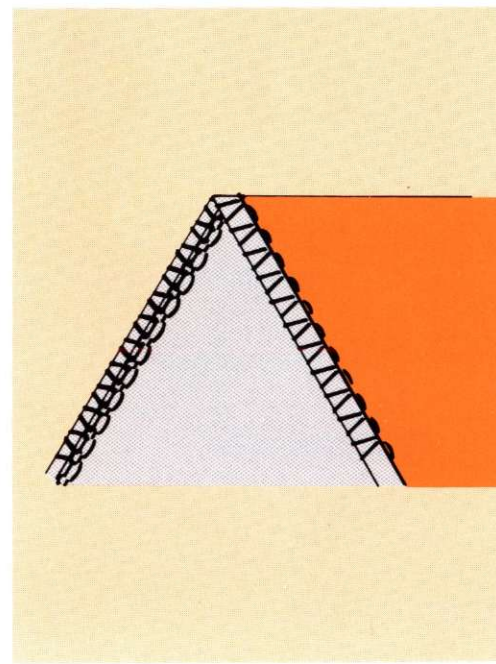
- (d) The needle thread lies flat and straight, to the left, and locks with the lower looper thread on the top side of the fabric and as a flat V-shape on the underside.
- (e) The lower looper thread lies flat on the top side of the fabric and locks on the edge with the needle thread.



4. To have the needle thread (d) pulled up over the fabric edge to the top side of the fabric, increase the needle thread tension and/or the lower thread tension.



5. To have the lower looper thread (e) pulled down over the fabric edge to the underside of the fabric, increase the lower looper tension and/or decrease the needle thread tension.



### 2-Thread Rolled Hem (Model 624)

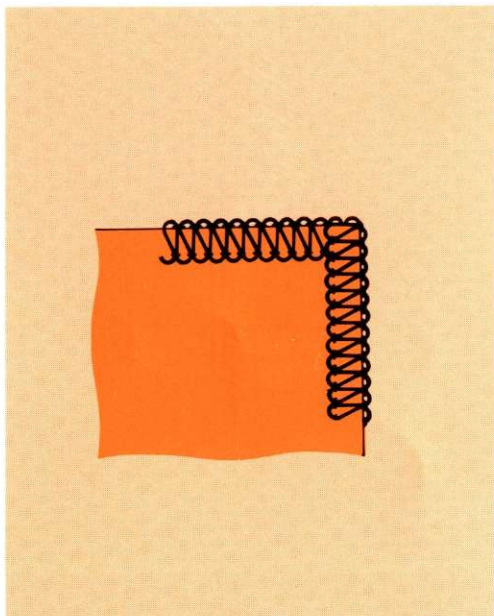
With the 2-thread convertor and using the right needle, your machine can sew a 2-thread rolled hem. Tighten the needle tension so that the lower looper thread is completely rolled down to the underside of the fabric.



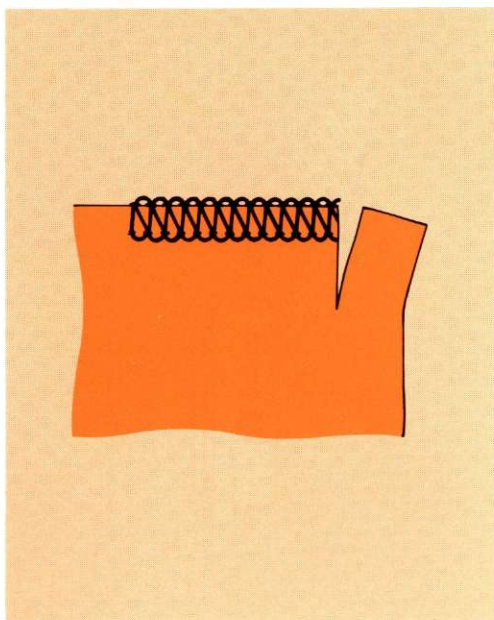
# OTHER SEWING APPLICATIONS

## Turning Outside Corners without Cutting the Threads

1. When you reach the end of the fabric, stop stitching with the needle above the fabric. Raise the presser foot. Gently pull the chain of thread out from the needle plate, leaving 2 or 3 loops of thread on the stitch finger. Turn the fabric, lower the presser foot and commence stitching in the new direction.

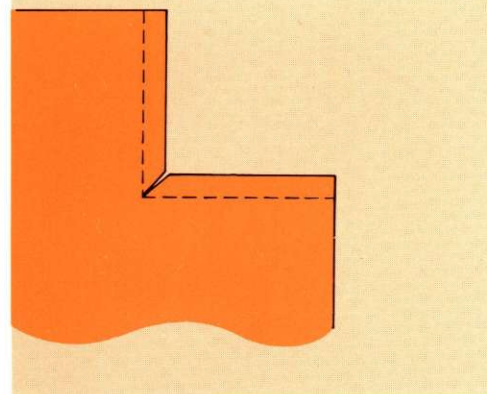


2. When overlocking and trimming at the same time, cut the fabric by hand along the new stitching line for about 3 cm, before turning the fabric. It is preferable to make a small cut to mark the second stitch line, before starting to sew.

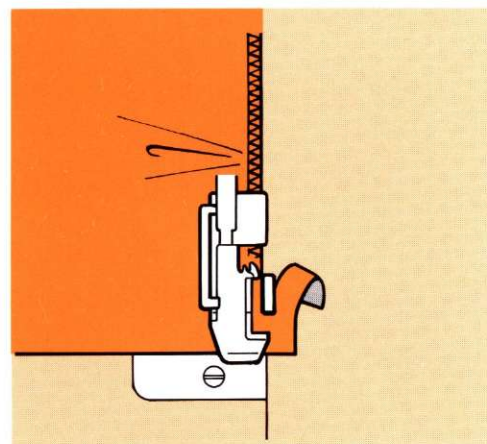


## Overlocking Inside Corners

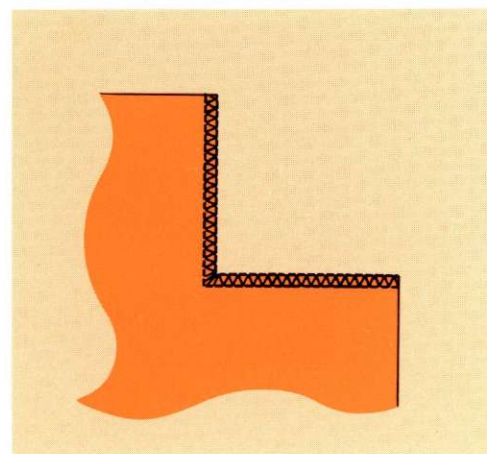
1. When overlocking an inside corner on a pocket, etc., clip about 3 to 4 mm into the corner.



2. Fold the fabric into a straight edge, as shown, and sew along the edge, trimming very little, if necessary.



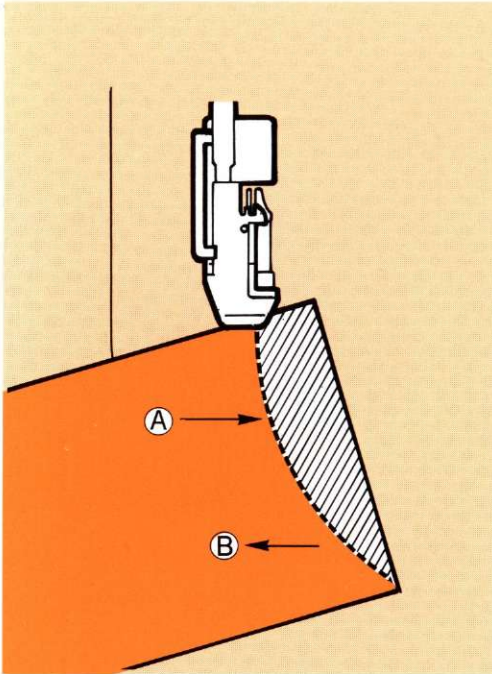
3. Open and press the fabric.



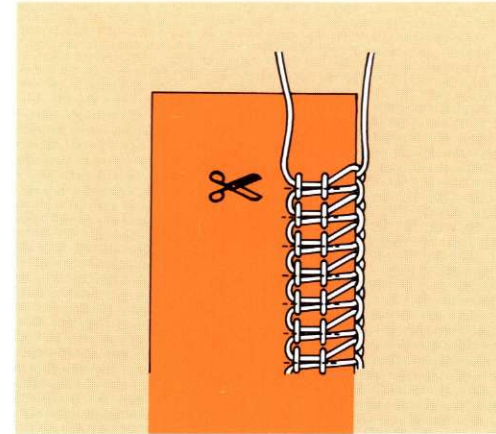
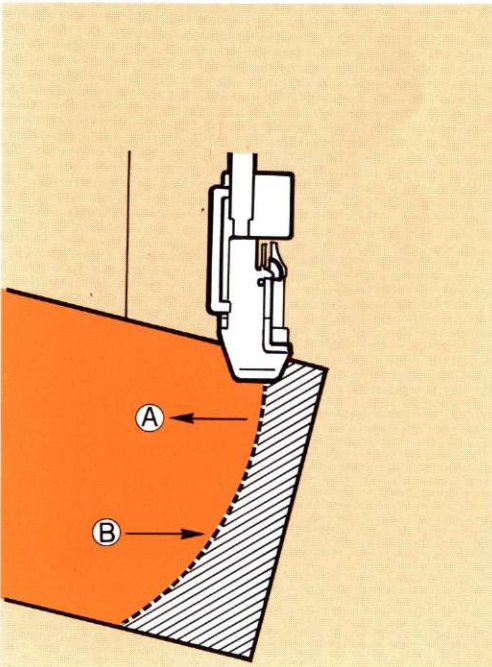


## Turning Curved Edges

1. For inside curves, guide the fabric gently, applying pressure with your left hand at point "A" in the direction of the arrow, and at the same time applying a little pressure in the opposite direction with your right hand at point "B".

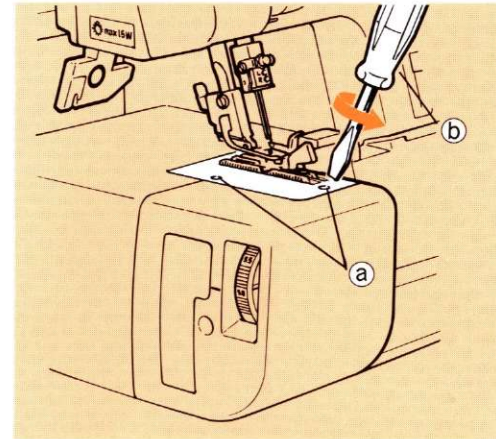


2. For outside curves, sew in a similar manner, but applying the pressure in the opposite directions.



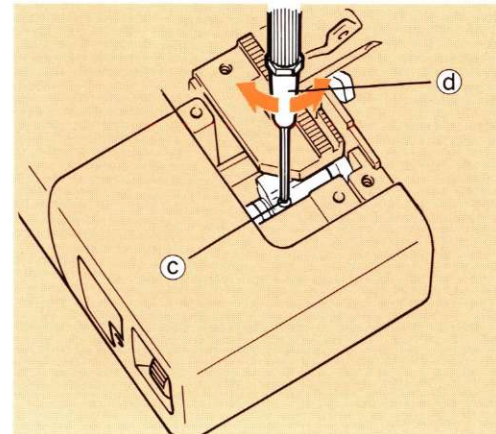
## Removing Stitches from Sewn Fabric

1. Snip the needle thread(s) at intervals. Then gently pull the looper thread; the stitching will unravel and be easy to remove.



## Sewing Extra Heavy Fabrics

Before sewing extra heavy fabrics, it is advisable to lock the moving blade. Remove the sewing foot (see page 5). Loosen the screws (a) with the screwdriver (b) so that the needle plate can be taken off.



Tighten the screw (c) with the Allen screwdriver (d) to lock the moving blade. Refit the needle plate and the sewing foot.

After sewing extra heavy fabrics, always loosen this screw slightly, to unlock the blade for normal sewing.

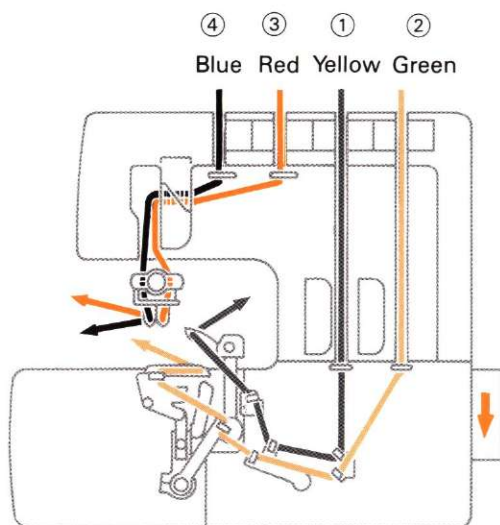






# STITCH SELECTION CHART

The thread tension values, stitch length, needle position(s) and differential feed are basic settings and must be adjusted or corrected depending on the fabric and the threads.



- ③ Right needle thread tension values  
④ Left needle thread tension values

Needle position(s)

L = Left  
R = Right

## 4 THREAD

Needles	Blue	Red	Yellow	Green	DF	SL
	5.0	3.0	2.0	2.0	1.0	2.5
L R	UP	UP				

Position of moving blade

Position of instant rolled/narrow hem device

- ① Upper looper thread tension values  
② Lower looper thread tension values

Stitch length

Differential feed

## STRETCH KNIT

Needles	Blue	Red	Yellow	Green	DF	SL
	3.5	3.0	2.0	2.0	1.5	3.0
L R	UP	UP				

## 3 THREAD

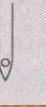


Needles	Blue	Red	Yellow	Green	DF	SL
	---	4.0	3.0	1.0	1.0	2.5
L R	UP	UP				

## 3 THREAD WIDE

Needles	Blue	Red	Yellow	Green	DF	SL
	4.0	---	2.0	1.5	1.0	2.5
L R	UP	UP				



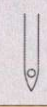


## FLATLOCK 3

Needles	Blue	Red	Yellow	Green	DF	SL
	0.0	---	2.0	8.5	1.0	2.0
L R						

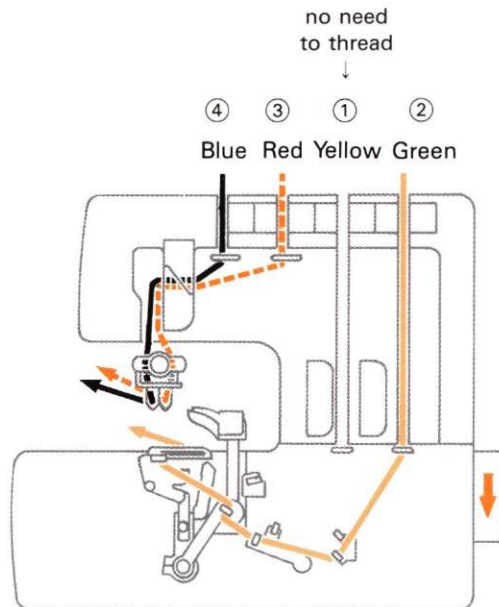
## NARROW HEM 3

Needles	Blue	Red	Yellow	Green	DF	SL
	---	3.0	4.0	2.0	1.0	1.0
L R						

## ROLLED HEM 3

Needles	Blue	Red	Yellow	Green	DF	SL
	---	3.0	2.0	7.0	1.0	1.0
L R						

### (Model 624)



With the 2-thread convertor and a single needle, your machine can sew a 2-thread flatlock, 2-thread overcast and 2-thread rolled hem.

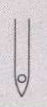



First fit the 2-thread convertor on to the upper looper (see page 13).

When using the right needle tension (Red), thread the right (R) needle.

When using the left needle tension (Blue), thread the left (L) needle.

\* By using the left needle and the left needle thread tension (Blue), you can also sew a 2-thread overcast wide.

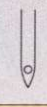



## FLATLOCK 2

Needles	Blue	Red	Yellow	Green	DF	SL
	0.0	---	---	5.0	1.0	2.0
L R						

## OVERCAST 2

Needles	Blue	Red	Yellow	Green	DF	SL
	---	0.5	---	6.0	1.0	2.0
L R						

## ROLLED HEM 2

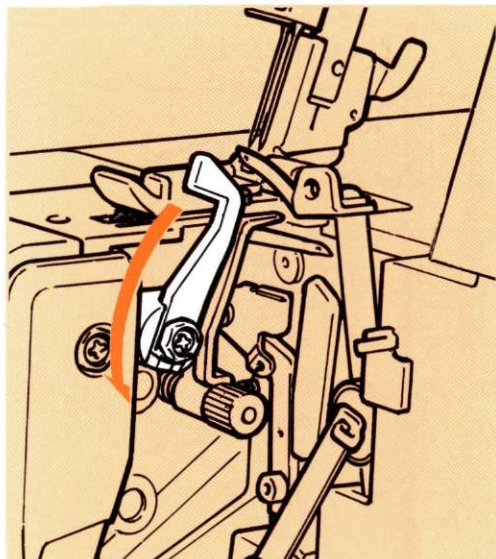
Needles	Blue	Red	Yellow	Green	DF	SL
	---	3.0	---	2.5	1.0	1.0
L R						



# MAINTENANCE

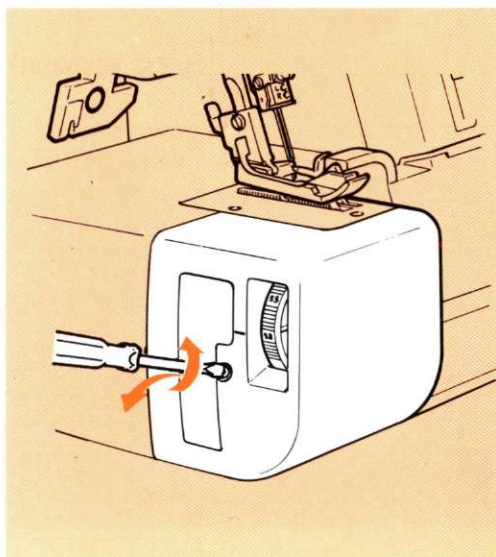
Your machine will always serve you faithfully, if it is cared for properly.

First unplug the machine according to the "Important Safety Instructions" on page "0".

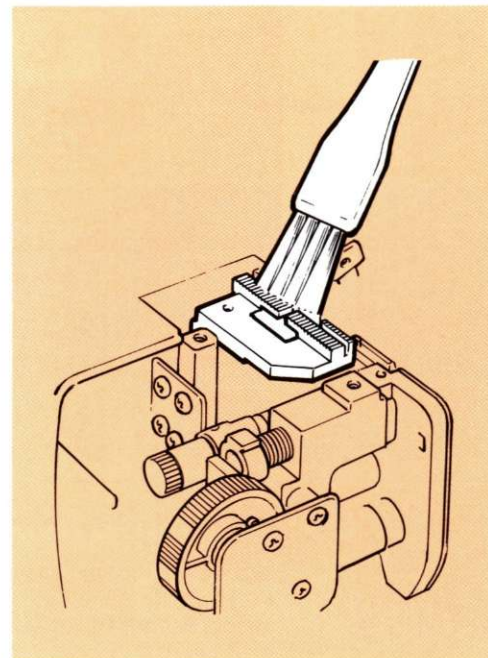


## Cleaning and Oiling the Machine

1. Open the front door.
2. Disengage the moving blade (see page 11).



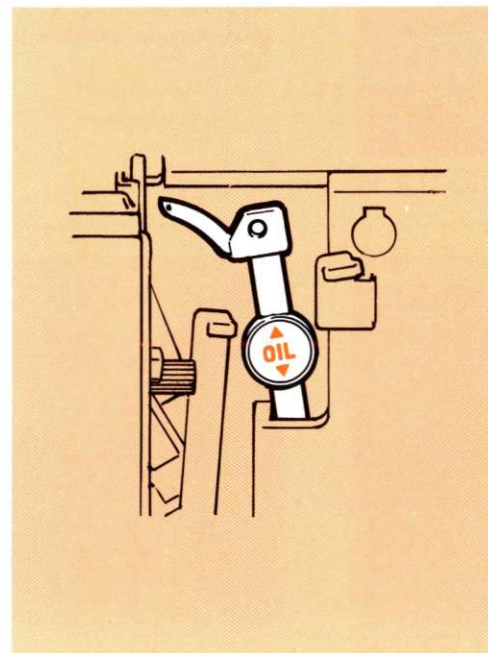
3. Remove the screw cap and loosen the screw so that side cover can be taken off.
4. Remove the sewing foot (see page 5) and the needle plate (see page 16).



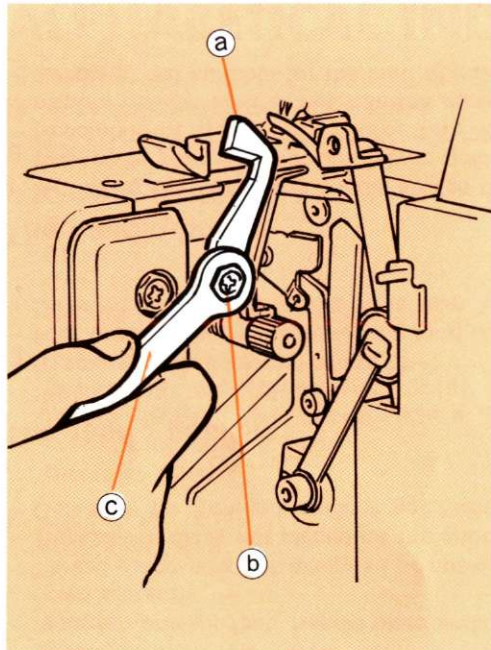
5. Brush the blade, feed dogs and the area around it. Clean any accumulation of lint, etc. inside the machine.
6. Refit the needle plate, sewing foot, side cover and screw cap.
7. Re-engage the moving blade (see page 11).
8. Oil the machine, as mentioned below under "Lubrication".

## Lubrication

When using your machine for the first time, or if you have not used it for some time, put a few drops of oil on the point indicated. Wipe off any oil remaining around the sewing area.







## Replacing the Moving Blade

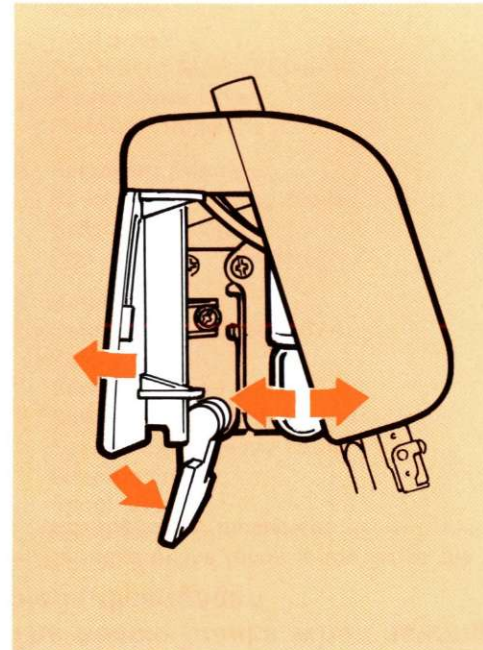
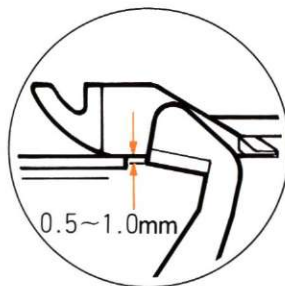
Replace the moving blade, if it becomes blunt. Proceed as follows (a spare moving blade can be found in the accessory box):

### First unplug the machine.

1. Open the front door and remove the side cover (see page 20).
2. Set the moving blade (a) in its engaged position and lock it (see page 16), then remove it by loosening the bolt (b) with the wrench (c) found in the accessory box.  
Brush the fixed blade and the surrounding area to clean any accumulation of lint, etc.
3. Lower the moving blade to the lowest position by turning the flywheel towards you. Put a new moving blade in place making sure that its edge is approximately 0.5 to 1.0 mm below the surface of the fixed blade. Tighten the bolt (b) firmly.
4. Unlock the moving blade, refit the side cover and screw cap. Close the front door.

### N.B.

The fixed blade is made of a special alloy and will rarely need to be replaced.



## Changing the Light Bulb

Unplug the machine before replacing the bulb.

Remember maximum input of the lamp is 15 watts, should it have to be changed. Raise the presser foot and swing open the lamp cover. Unscrew the light bulb and replace the bulb by following the same procedure in the reverse order.



# MINOR DISORDERS

Refer to the following pages for information:

## The stitches are irregular or skipped

- Incorrect threading ..... 6-7
- Looper thread guide not set properly. Push it up to the working position and thread the lower looper ..... 6
- Incorrect thread tension(s) ..... 9, 12, 14, 18-19
- Needle(s) not system EL x 705 or 130/705H (15 x 1), of poor quality, bent or not inserted correctly ..... 5
- Pulling fabric: do not pull fabric; guide gently ..... 12
- Incorrect presser foot. Needle plate and/or presser foot not fitted correctly ..... 5, 11, 20
- Thread guide pole not extended or not positioned properly ..... 4

## The thread breaks

- Incorrect threading ..... 6-7
- Thread or thread spool tangled ..... 10-12
- Incorrect thread tension(s) ..... 9, 12, 14, 18-19
- When re-threading the lower looper, first remove the thread from the rear needle ..... 6-7
- Incorrect presser foot. Needle plate and/or presser foot not fitted correctly ..... 5, 11, 20
- Thread guide pole not extended or not positioned properly ..... 4
- Transparent discs not placed on the spool pins ..... 4
- Convertor for 2-thread overlock not fitted correctly (Model 624) ..... 13

## The fabric puckers

- Stitch length too long ..... 10, 18-19
- Needle thread tension(s) too tight ..... 9, 14, 18-19
- Foot pressure not suitable for the kind of fabric ..... 11
- Differential feed slide set at more than 1 (Models 624 & 614) ..... 10

## The needle breaks

- By pulling the fabric, the needle strikes the foot or the needle plate—do not pull fabric; guide gently ..... 12
- Needle(s) not system EL x 705 or 130/705H (15 x 1), of poor quality, bent or not inserted correctly ..... 5
- Needle(s) not suitable for the kind of work ..... 5, 18-19

## The machine jams

- Stitch length too short ..... 10, 18-19
- Needle thread tension(s) too tight ..... 9, 14, 18-19
- Incorrect thread tension(s) ..... 9, 12, 14, 18-19

## The machine runs noisily

- Clean and oil ..... 20
- Brush both blades ..... 20
- Needle blunt or bent ..... 5
- Check thread tension(s) ..... 9, 12, 14, 18-19

## The fabric is not cut at all

- Moving blade not engaged correctly ..... 11, 21

## The fabric is not cut properly

- Cutting position not set correctly ..... 11, 21
- Moving blade not fitted properly ..... 21
- Brush both blades ..... 20
- Moving blade needs replacing ..... 21

## The needle breaks when sewing with the moving blade disengaged

- The edge of the fabric is too far to the right and interferes with the looper movement ..... 15, 18-19



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## YOUR MACHINE

Record in the space provided below the Serial No. and Model No. of this appliance.

These numbers are located on the specification plate. Retain them for future reference.

Serial No. \_\_\_\_\_

Model No. \_\_\_\_\_

All rights to make any modifications reserved.







## NOTES



